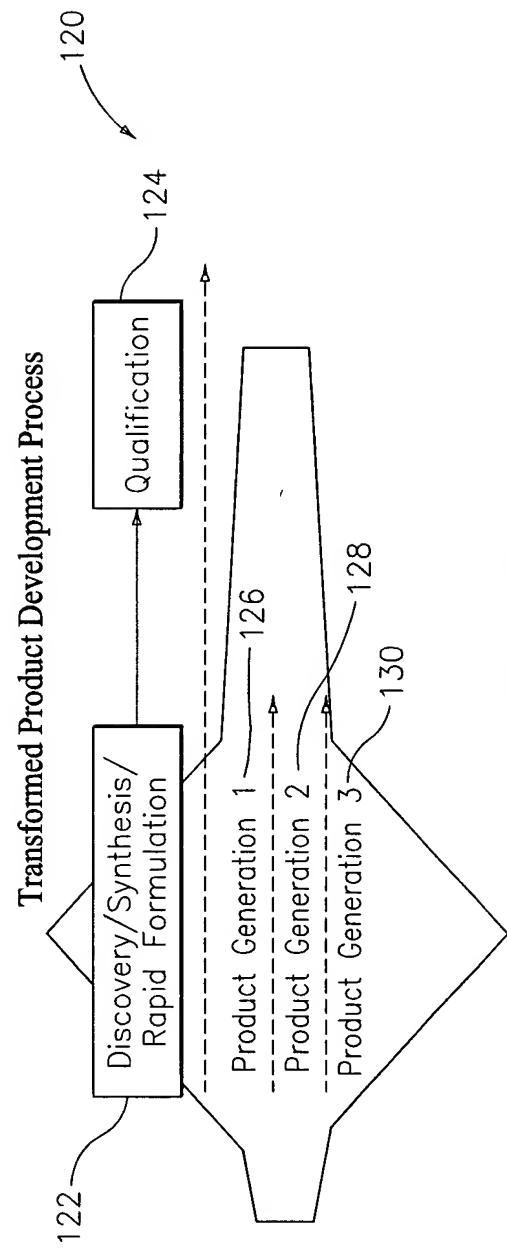


*FIG. 1a  
(PRIOR ART)*



*FIG. 1b*



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### Implementation of Transformed Product Development Process

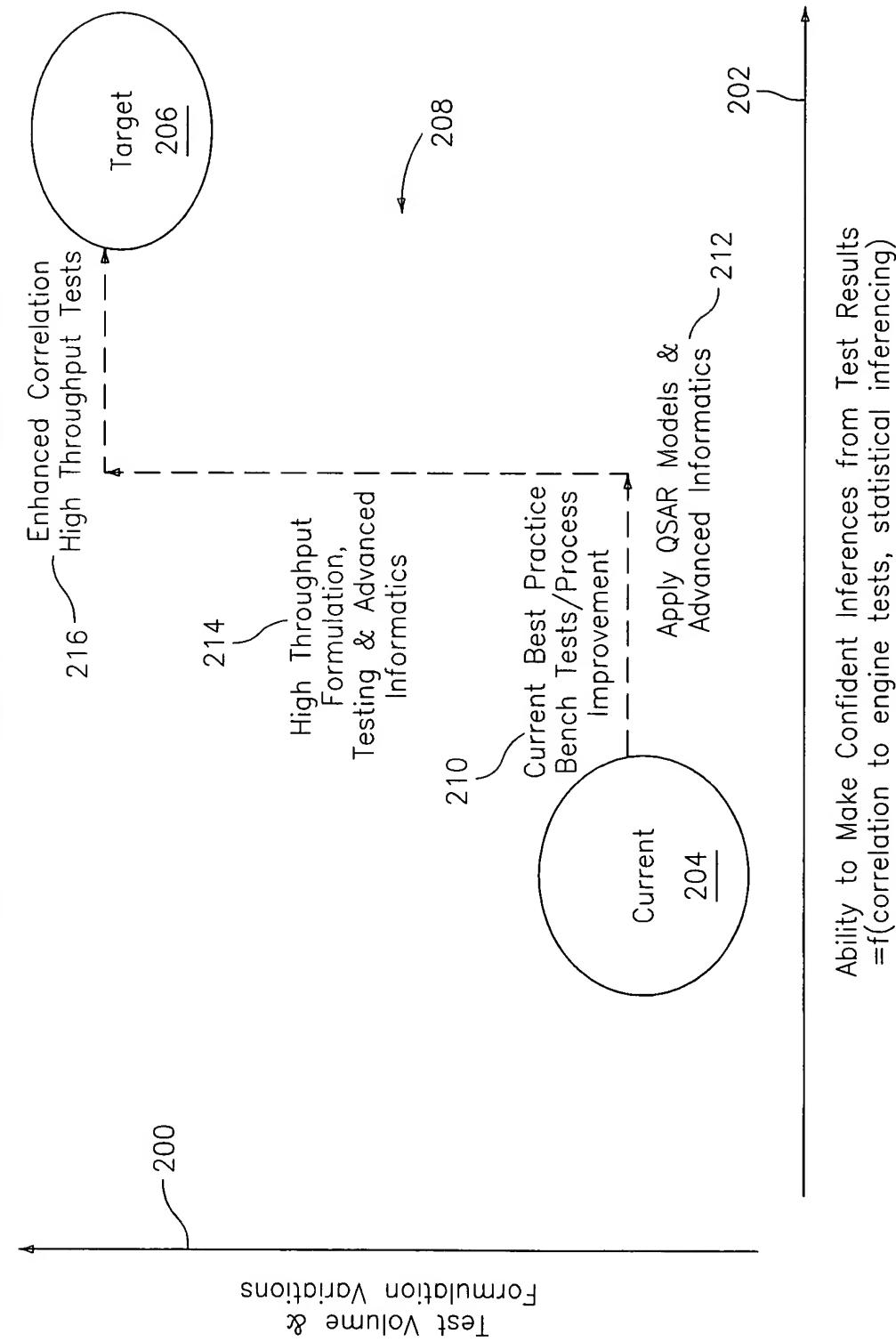


FIG. 2

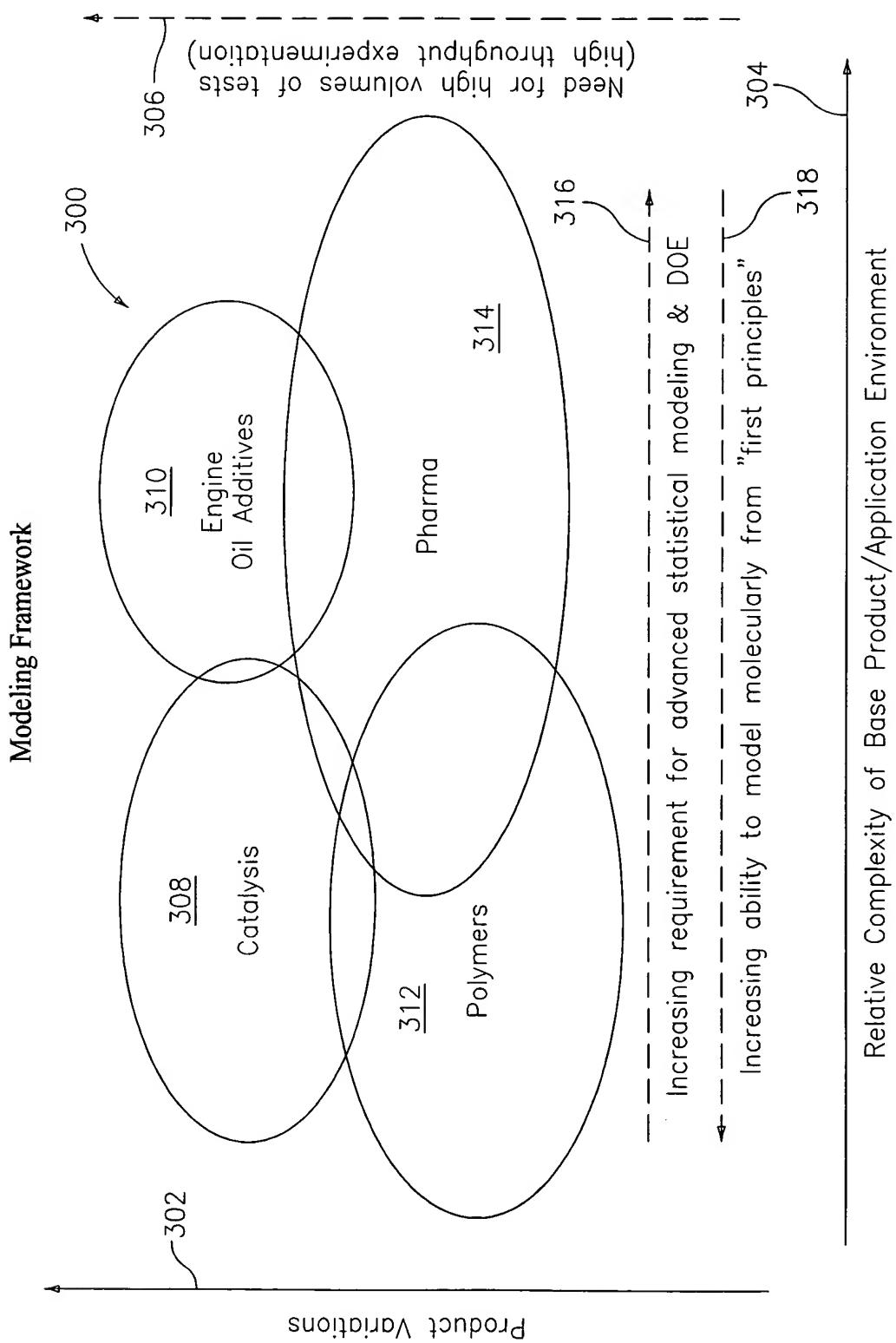
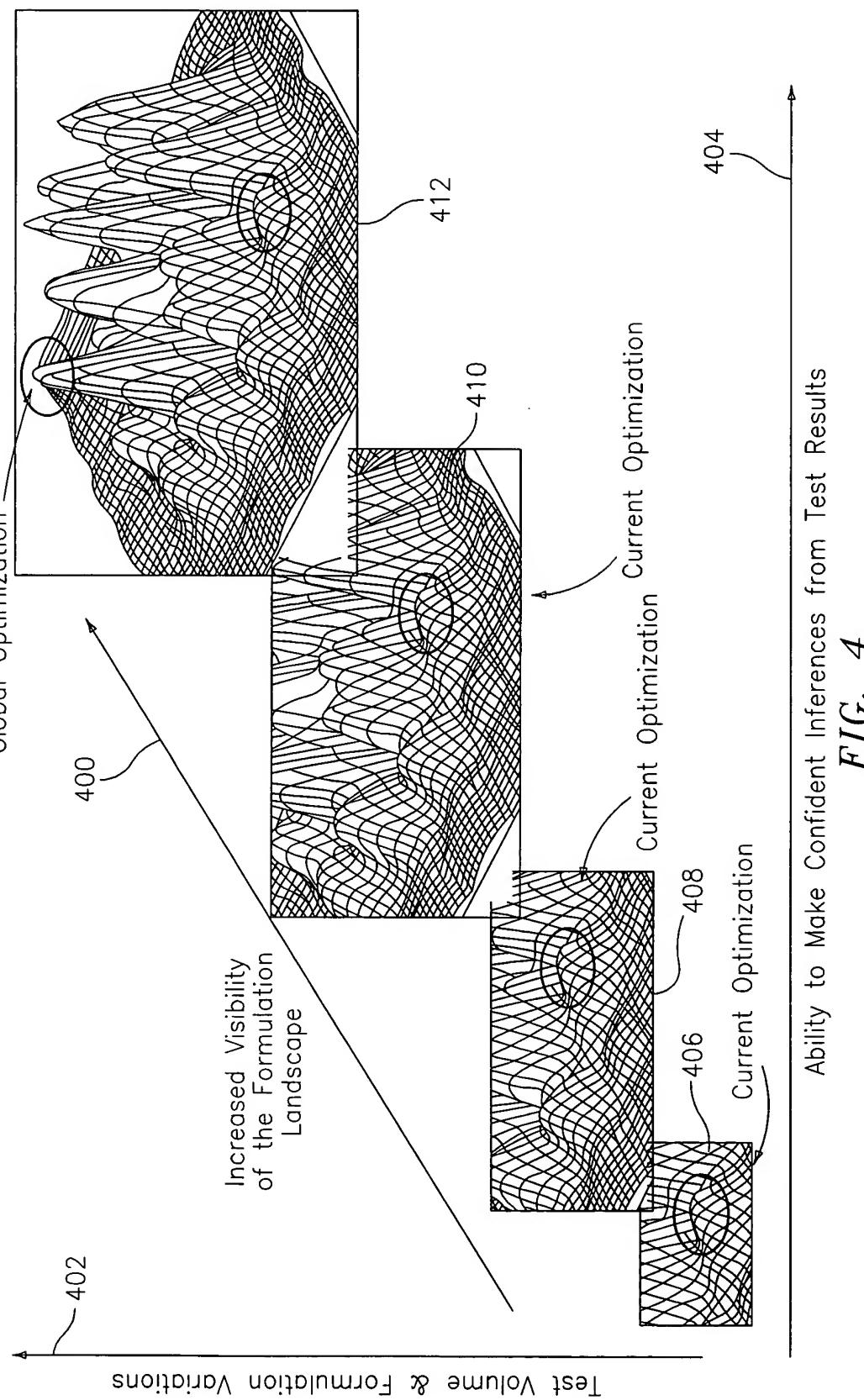


FIG. 3

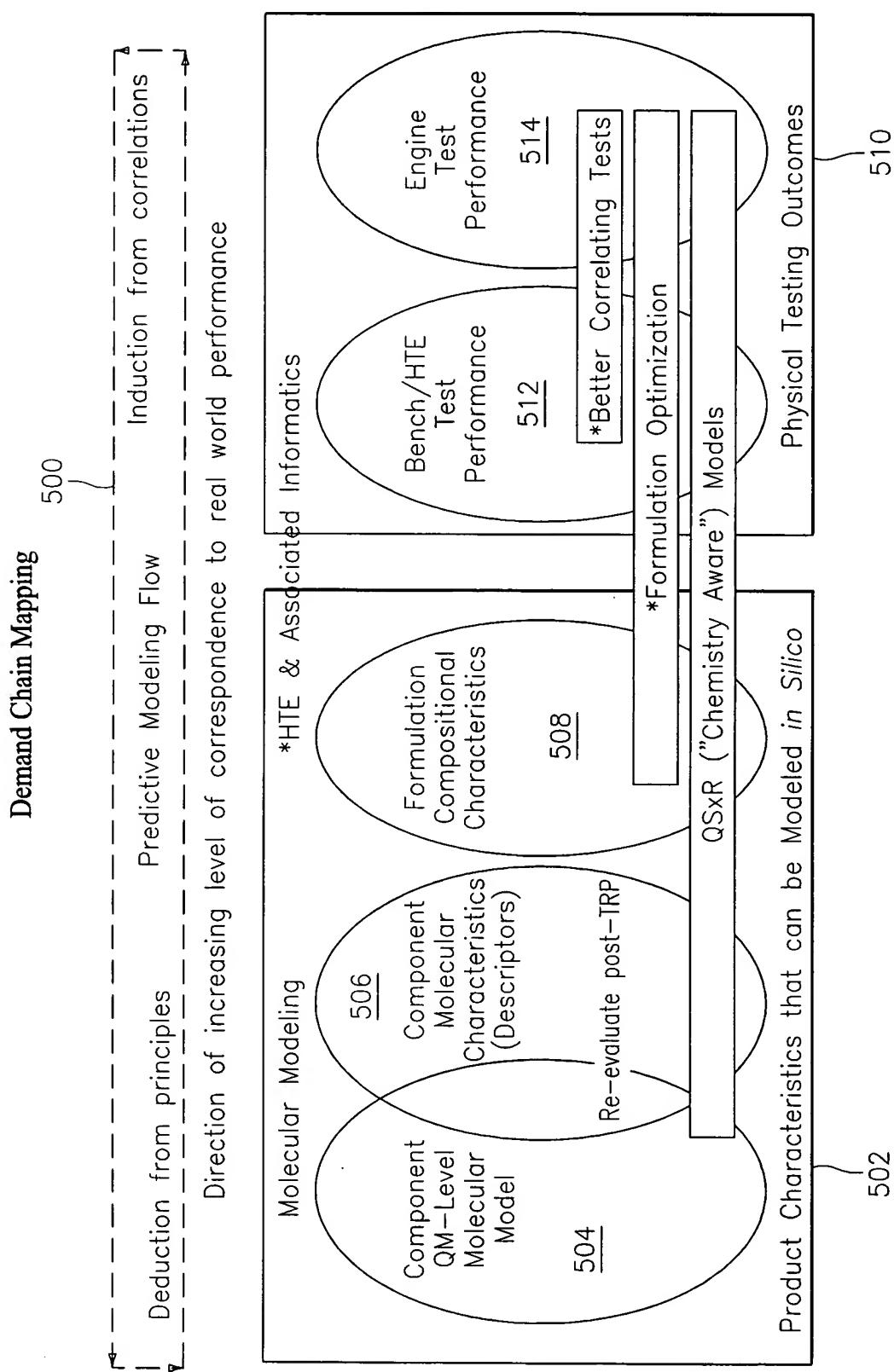
Understanding the Formulation Landscape in order to Improve it.

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Ability to Make Confident Inferences from Test Results

**FIG. 4**

**FIG. 5**